

WHAT IS CLAIMED IS:

1. A manufacturing method for a toner container provided with an opening, said method comprising:

5 a filling step of filling the toner container with toner through an opening;

a closing step of setting a cap member and closing the opening with the cap member, after said filling step;

10 a sealing step of sealing the opening by vibration welding of the cap member to the toner container by a welding jig,

wherein the cap member is welded to the toner container while imparting a relative movement of the welding jig relative to the toner container toward an 15 un-welded portion.

20 2. An apparatus according to Claim 1, further comprising a fixing step of fixing a position of the toner container and substantially preventing movement, and said filling step is effected after said fixing step.

25 3. An apparatus according to Claim 2, wherein said relative movement is provided by moving the welding jig.

4. A method according to any one of Claims 1-3,

further comprising a pressing step of pressing the cap member into the toner container by a pressing jig after the cap member is set in the toner container.

5 5. An apparatus according to Claim 4, wherein said sealing step is effected with the cap member pressed into the toner container.

10 6. An apparatus according to Claim 1, wherein the cap member is ultrasonic-welded to the toner container by the welding jig.

15 7. An apparatus according to Claim 1, wherein in the sealing step, the welding jig is circulated around the opening to return to a start point of welding.

8. An apparatus according to Claim 1, wherein the welding jig has a projected free end.

20 9. An apparatus according to Claim 1, wherein the opening functions to permit removal of a mold during injection molding of the toner container.

25 10. A toner container detachably mountable to an image forming apparatus, said toner container comprising:

 a container body;

an opening provided in said container body;
a cap member for closing the opening;
wherein the cap member is welded to the toner
container while imparting a relative movement of the
5 welding jig relative to said container body toward an
un-welded portion to seal the opening by vibration
welding of said cap member to said container body
using a welding jig after filling the toner into said
container body through the opening.

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11. An apparatus according to Claim 10, wherein
the opening accept filling toner with a position of
said toner container being substantially immovably
fixed.

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12. An apparatus according to Claim 11, wherein
said cap member is welded to said toner container by
moving the welding jig.

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13. A method according to any one of Claims 10-
12, wherein said cap member is welded while a pressing
jig presses said cap member.

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14. An apparatus according to Claim 10, wherein
said cap member is ultrasonic-welded to said toner
container by the welding jig.

15. A method according to Claim 10, wherein the cap member is welded while the welding jig is circulated around the opening to return to a start point of welding.

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16. An apparatus according to Claim 10, wherein the cap member is welded by the welding jig having a projected free end.

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17. An apparatus according to Claim 10, wherein the opening functions to permit removal of a mold during injection molding of the toner container.

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